



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5425-043
Job Sheet 188019



Part No: D5425-043

Job Qty: 1 ea

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/18

Job Tracking No:

Due Date: 2/20/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S143070



Part: D5425-043

Job No: 188019

Serial No/Batch: S143070

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/09/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/20/19	0.00	0.00	Start Up Skid tubes-2		
110	Skid tubes	1 pcs		2/20/19	0.00	8.24	Skid tubes-3		
120	CNC Vertical Machining	1 pcs		2/20/19	0.00	22.77	HAAS1-4		
130	QC	1 pcs		2/20/19	0.00	0.00	QC2 Machining-4		
140	QC	1 pcs		2/20/19	0.00	0.00	QC8 Machining-4		
150	HandFinish	1 pcs		2/20/19	0.00	0.24	HandFinish1		
160	QC	1 pcs		2/20/19	0.00	0.00	QC7-5		
170	CNC Bend Skid tubes	1 pcs		2/20/19	0.00	2.63	CNC Bend Skid tube		
180	QC	1 pcs		2/20/19	0.00	0.00	QC5		
190	Skid tubes	1 pcs		2/20/19	0.00	8.24	Skid tubes-3		
200	QC	1 pcs		2/20/19	0.00	0.00	QC5		
210	HandFinish	1 pcs		2/20/19	0.00	0.24	HandFinish6		
220	QC	1 pcs		2/20/19	0.00	0.00	QC7-5		
230	Skid tubes	1 pcs		2/20/19	0.00	8.24	Skid tubes-3		
240	QC	1 pcs		2/20/19	0.00	0.00	QC5		
250	HandFinish	1 pcs		2/20/19	0.00	0.24	HandFinish6		
260	QC	1 pcs		2/20/19	0.00	0.00	QC7-5		
270	SprayPaint	1 pcs		2/20/19	0.00	0.00	Spray Paint		
280	QC	1 pcs		2/20/19	0.00	0.00	QC14		
290	HandFinish	1 pcs		2/20/19	0.00	0.24	HandFinish4		
300	QC	1 pcs		2/20/19	0.00	0.00	QC5		
310	Packaging	1 pcs		2/20/19	0.00	0.00	Packaging3-2		
320	QC21-SA	1 Ea		2/20/19	0.00	0.00	QC21		

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Deburr ends as per Dwg.

Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: B FOLIO REV: AA 2-Deburr as per Dwg.

150 - 1-Scrub inside of tube with medium scotchbright.

170 - 1-Bend Aft end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at 20.0" from aft end. Use buggy A,B,C. to stabilize tube. HEIGHT 2-Bend Forward end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C To stabilize tube. HEIGHT 3-Record dimensions on work order.

180 - #NAME?

190 - 1-Drill remaining holes of DETAIL M, N, P. USING DT10340 A,B,C,D 2-Open holes to finished size as per Dwg. 3-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.

230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B 5108160 Start Time: 4:00pm Finish Time: 10:00pm ***CURE TIME 6HRS. BEFORE PROCEEDING TO NEXT STEP*** 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1

250 - ***DO NOT SUBMERGE TUBE IN DEOXIDIZER***

270 - ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5103577 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: 5123197290 - 1-Install FWD and AFT cap seal with sikaflex-241 / 291 5174342 Exp: 19/12 Start time: 8:00AM Finish time: 8PM 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon B 1133690

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 Ea (1 ea)	90-Start up Operation	<u>5017944</u>
D5518-1	Crossbolt Spacer	18 pcs (18 ea)	230-Skid tubes	<u>5148264</u>
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skid tubes	<u>5175351</u>
AN3C5A	Bolt	6 Ea (6 ea)	290-HandFinish	<u>5156446</u>
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-HandFinish	<u>5164008</u>
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-HandFinish	<u>5150717</u>
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-HandFinish	<u>5151947</u>
NAS1149C0332R	Washer	6 Ea (6 ea)	290-HandFinish	<u>5148669</u>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Route update only ☐

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6028-195	1	13	0
230-Skidtubes	D5512-1	12	40	0
	D5518-1	18	93	0
290-HandFinish	AN3C5A	6	1,249	0
	D3672-1	6	1,959	0
	D5483-041	1	0	0
	D5484-041	1	0	0
	NAS1149C0332R	6	3,130	0
Part Specifications				
Specifications could not be found.				

Plex 12/31/18 2:16 PM dart.white.jesse

Entered: _____ Date: _____



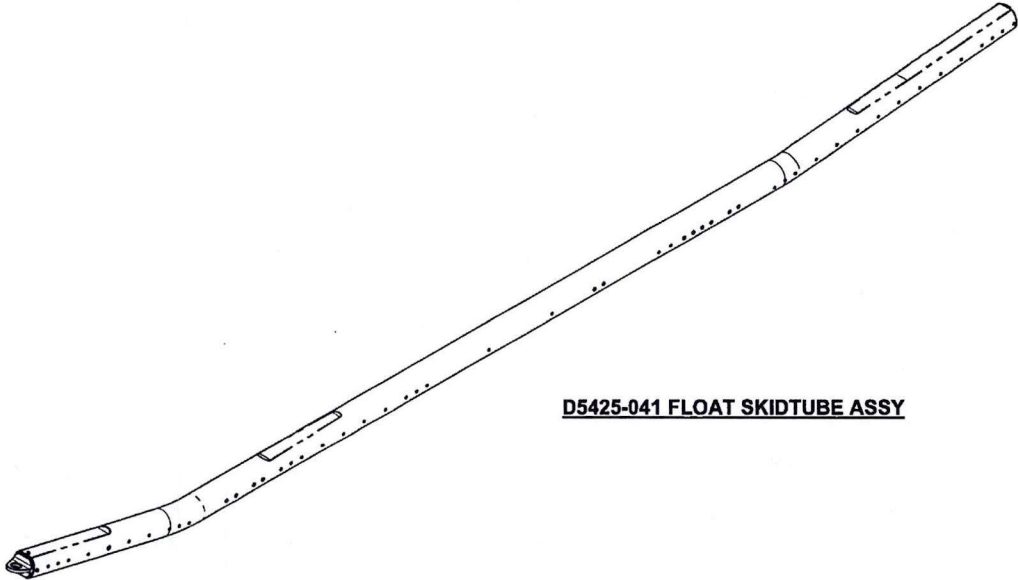
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NCR No. _____

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details:					

QTY -041	P/N	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER



D5425-041 FLOAT SKIDTUBE ASSY

RELEASED
2018 AUG 16
ECN 18-736

REV.	DESCRIPTION	BY	DATE
B	CHANGE HOLE SIZE TO IMPROVE OFF-AXIS SWAGING IN SHEETS 5 AND 6 (NCR18-6741). PICTORIAL UPDATE DUE TO CHANGES IN D5483-1.	NO	18.02.05
A	NEW ISSUE	NO	17.07.19

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 1 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
DATE	18.02.05	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

Entered: _____ Date: _____

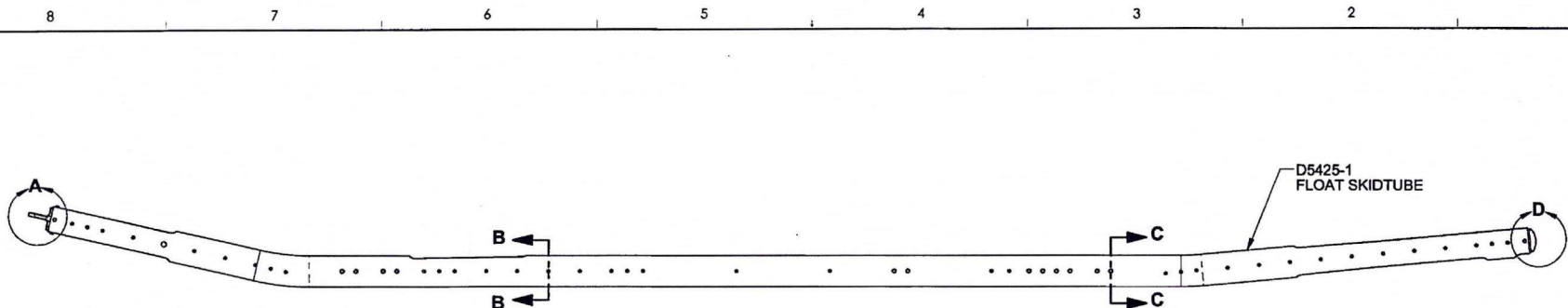


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

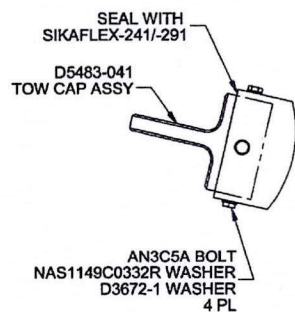
NCR No. _____

Route update only ☐

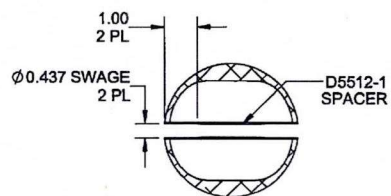
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Description Work Order Deviation		Disposition		Completed By	
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



D5425-041 FLOAT SKIDTUBE ASSY

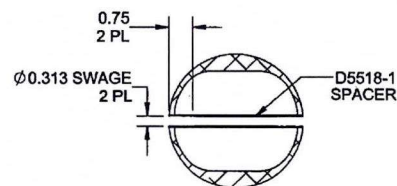


DETAIL A
SCALE 4X



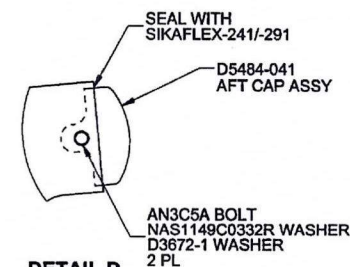
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION C-C
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B
SCALE 4X
37 PL



DETAIL D
SCALE 4X

RELEASED

2018 AUG 16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 54.5lbs
- 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

APPROVED

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 2 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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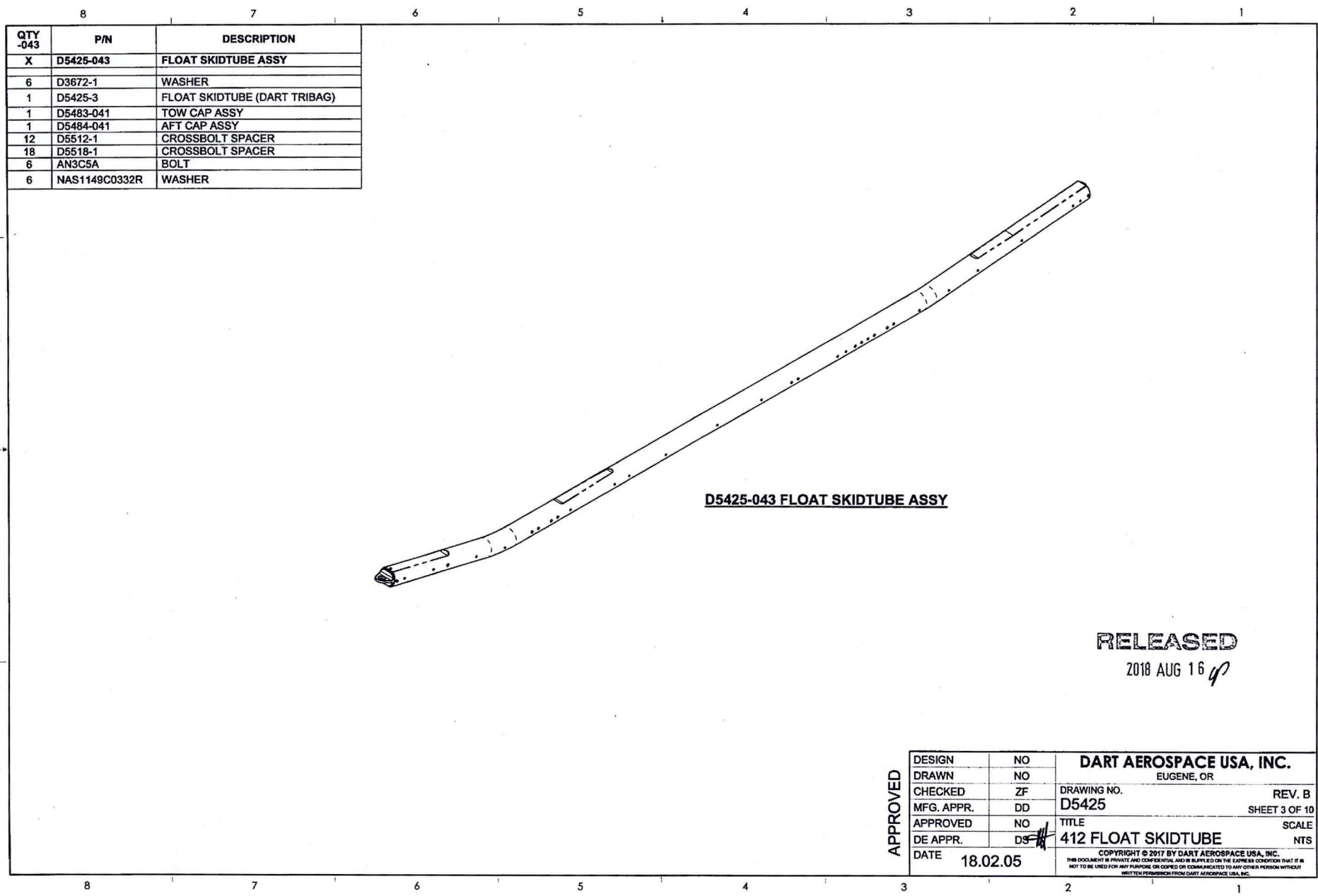


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
Other/Details:					



QTY -043	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
18	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER

D5425-043 FLOAT SKIDTUBE ASSY

RELEASED
2018 AUG 16 *g*

APPROVED	DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	NO		
	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 3 OF 10
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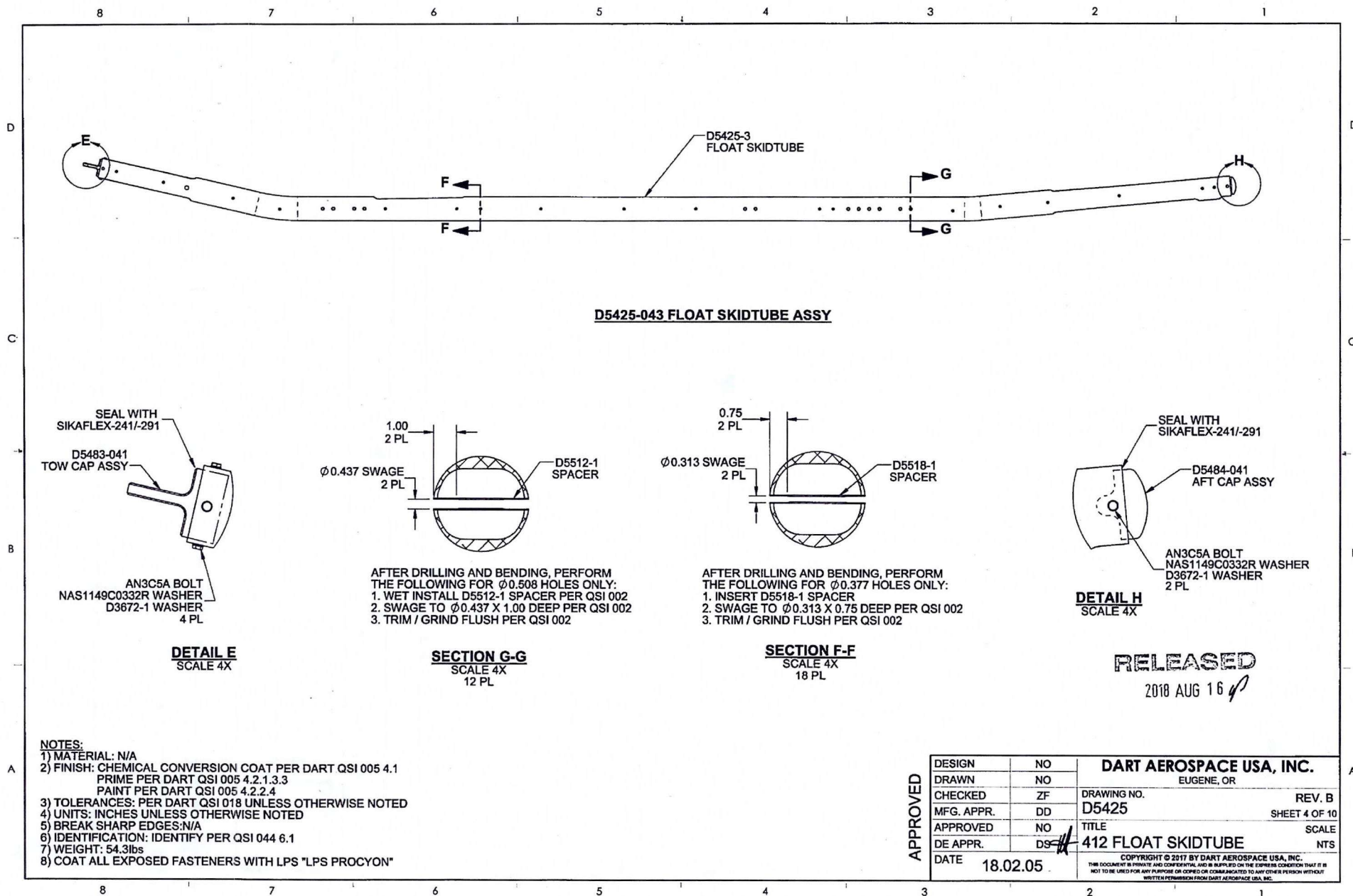


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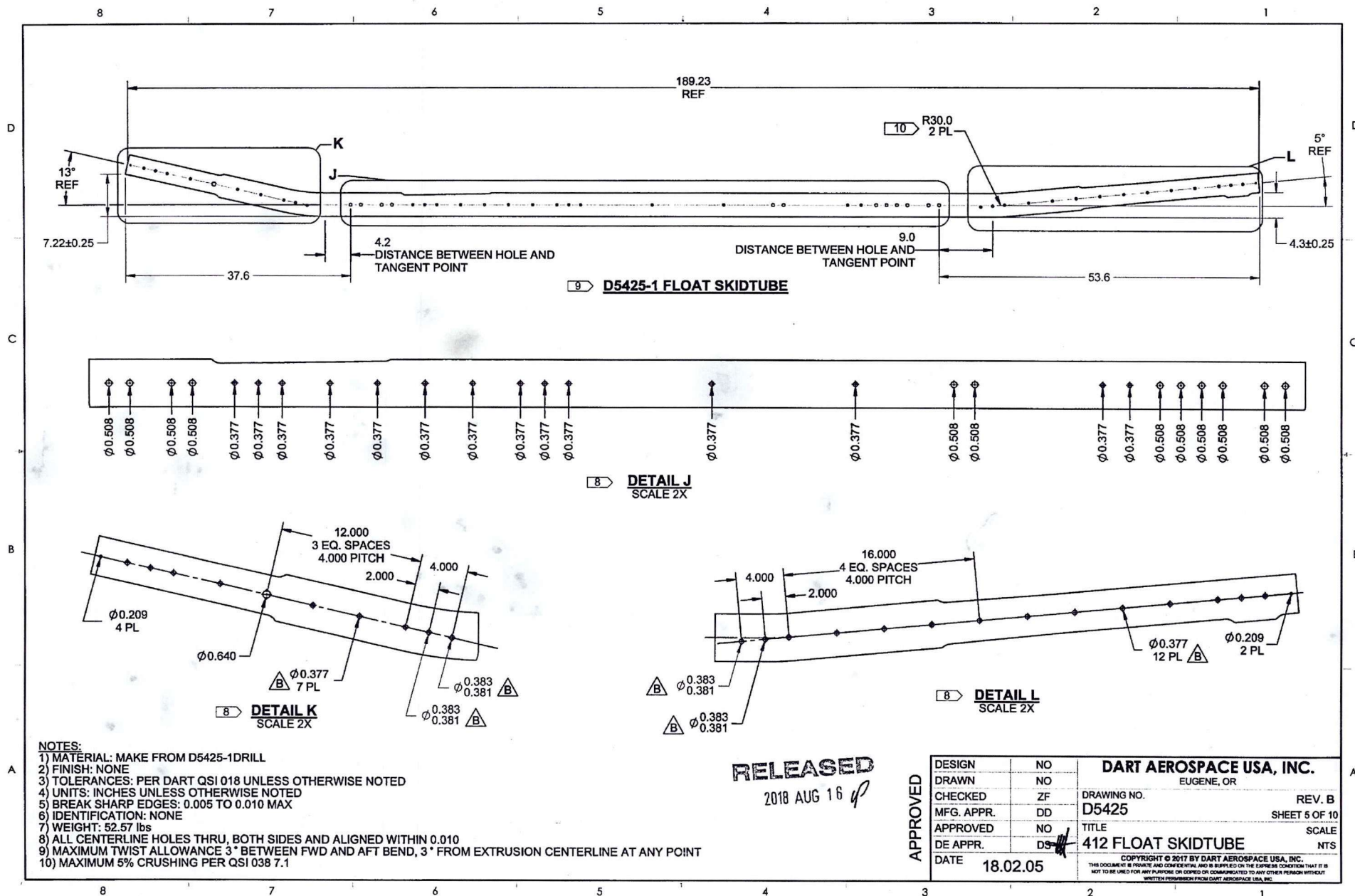


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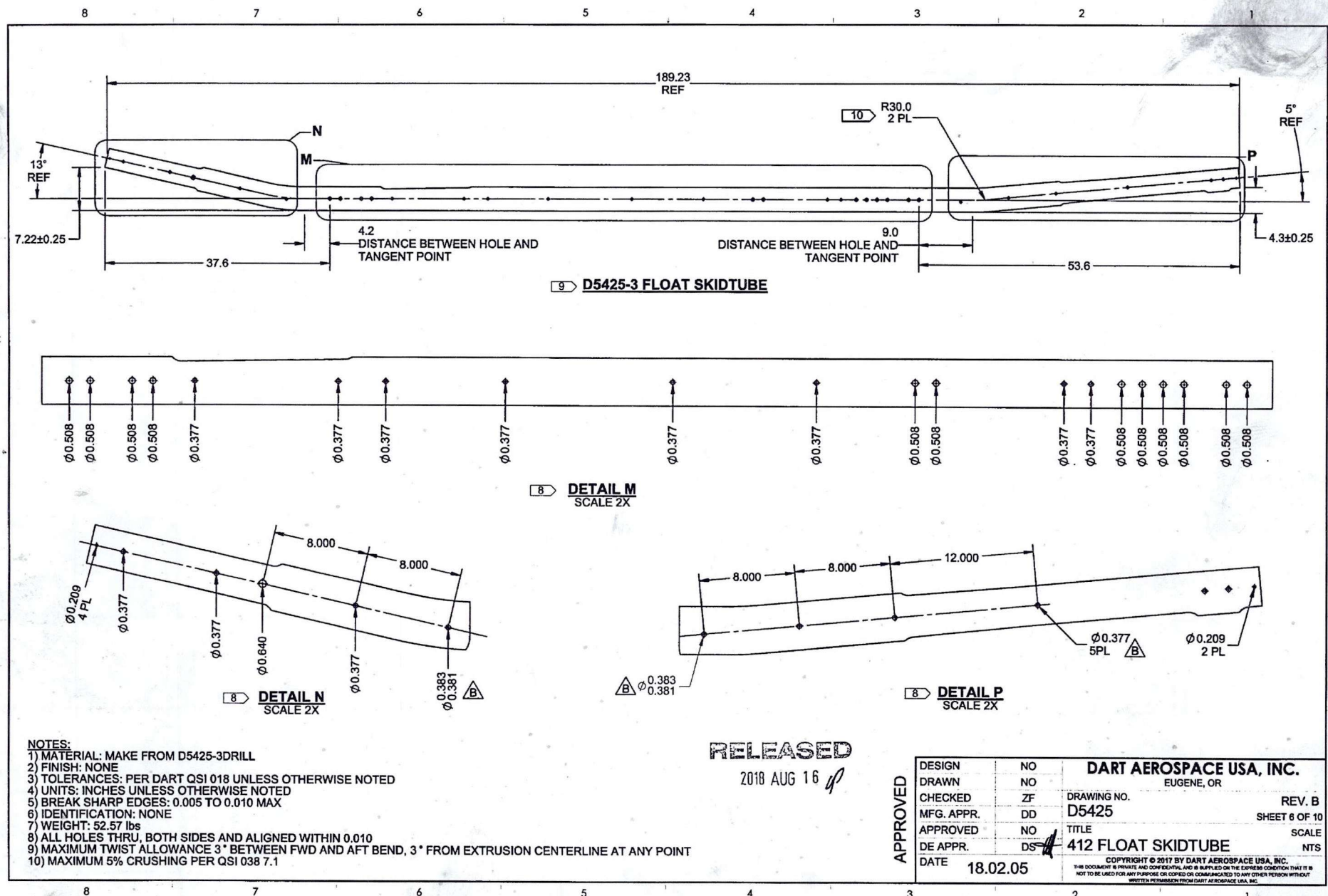


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Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Entered: _____ Date: _____

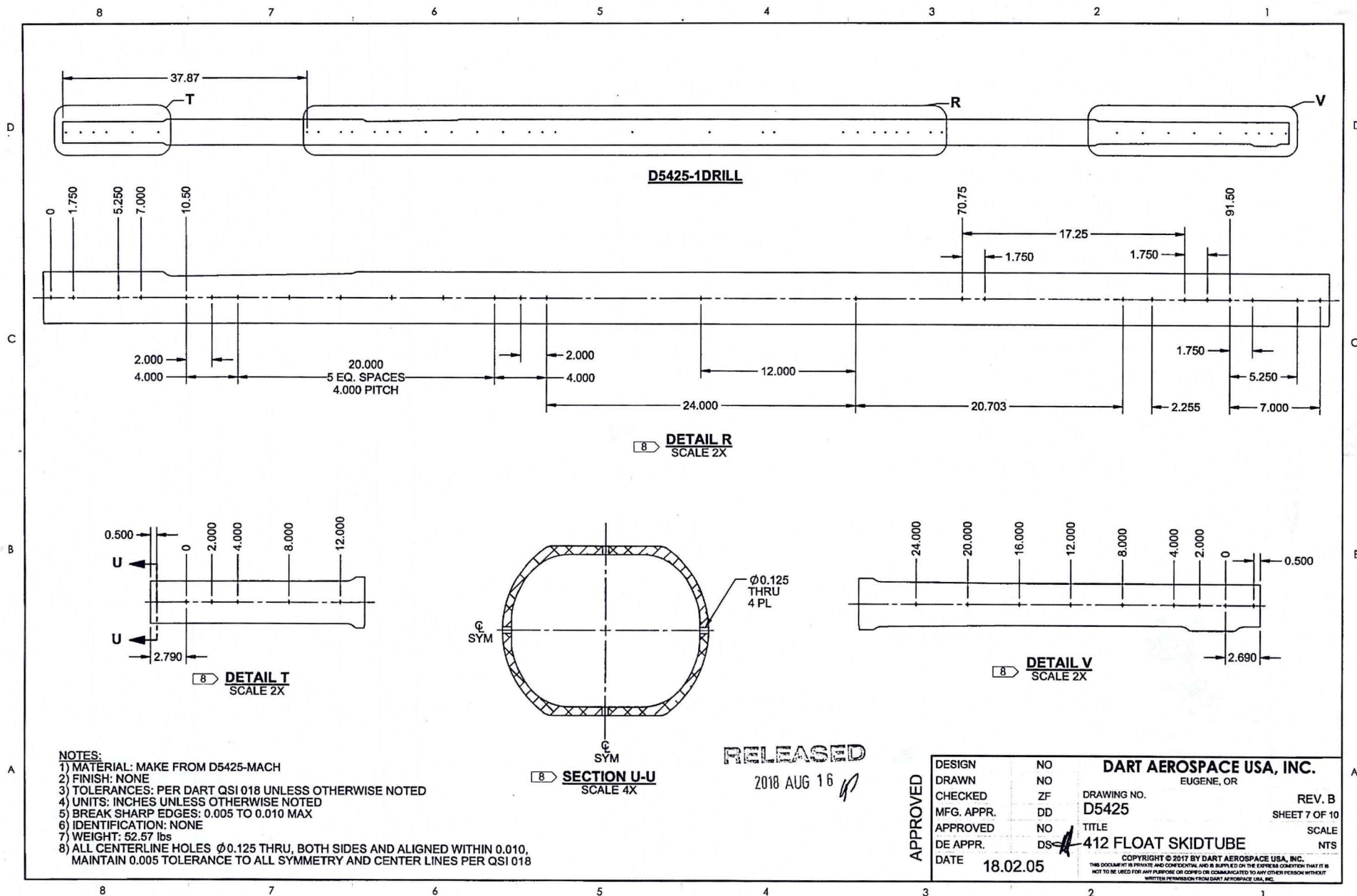


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Entered: _____ Date: _____

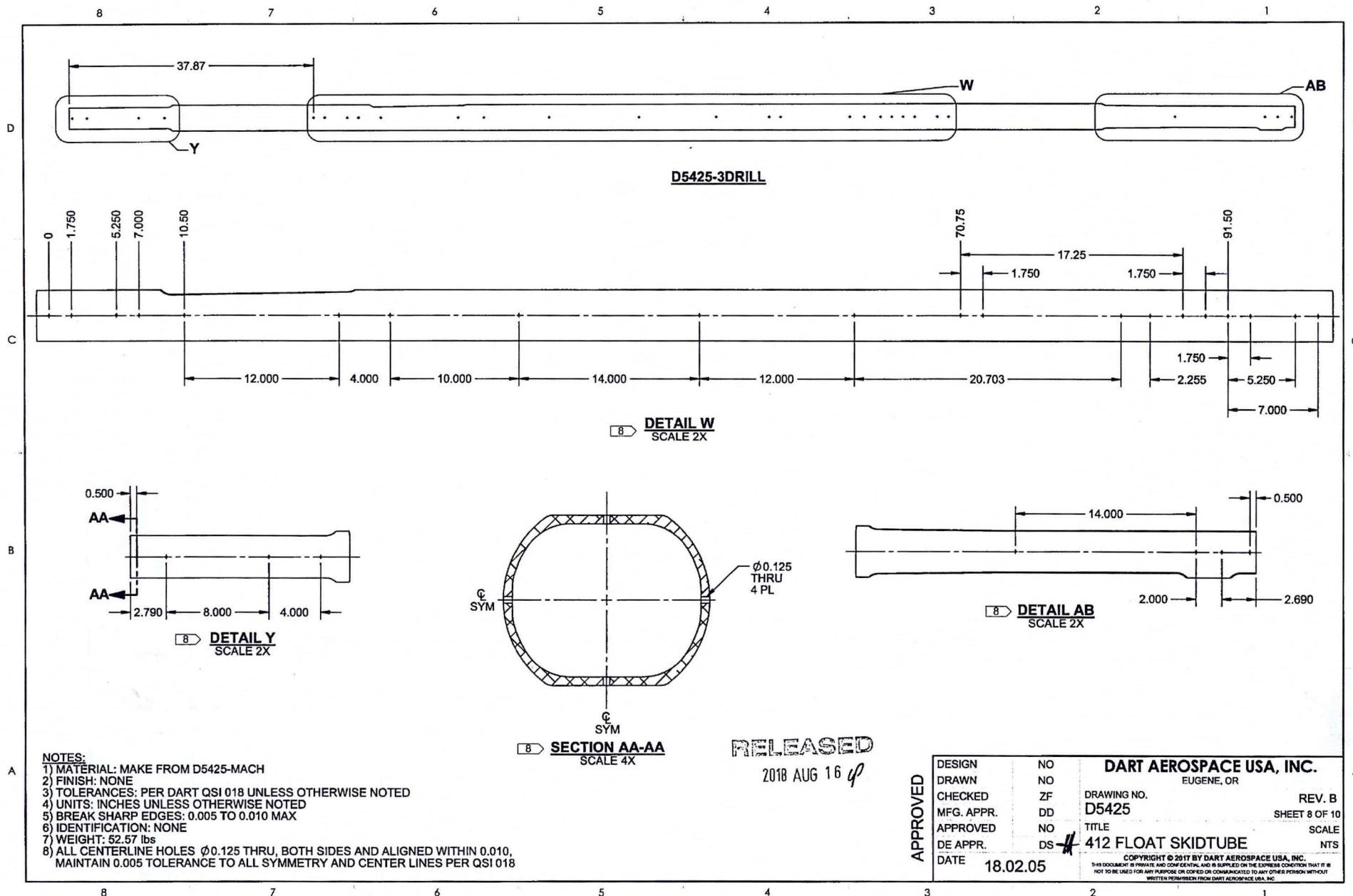


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details:					



Entered: _____ Date: _____

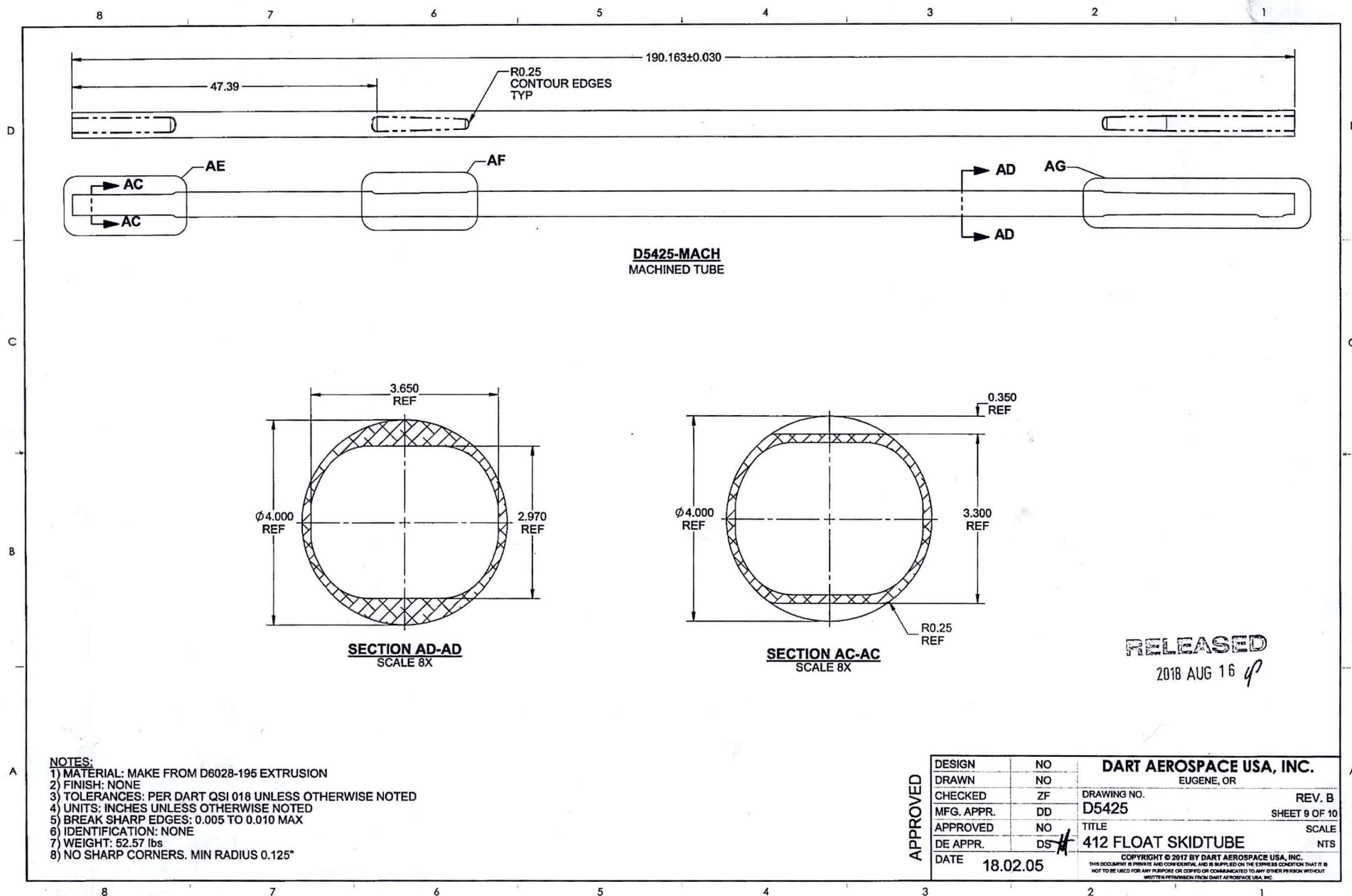


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details:					



Entered: _____ Date: _____



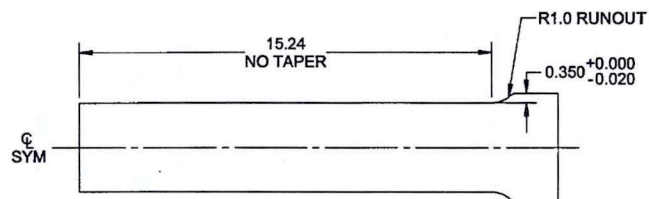
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

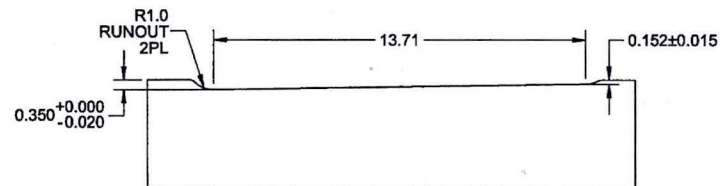
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Description Work Order Deviation		Disposition		Completed By	
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
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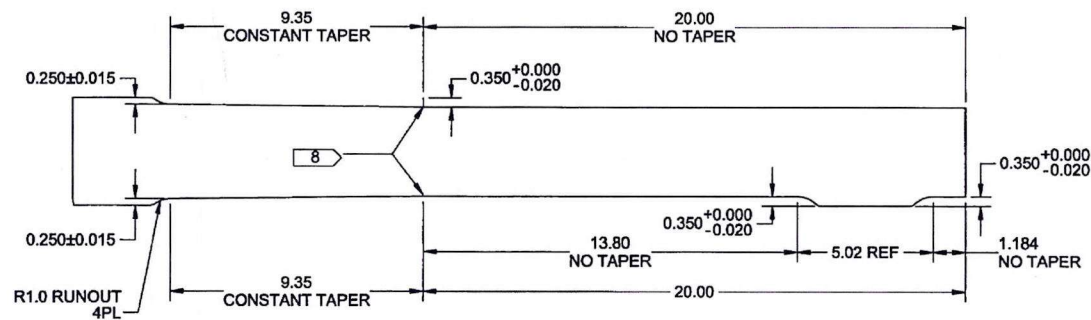
8 7 6 5 4 3 2 1



DETAIL AE
SCALE 3X



DETAIL AF
SCALE 3X



DETAIL AG
SCALE 3X

RELEASED

2018 AUG 16 *4P*

APPROVED

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 10 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
DATE	18.02.05	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

8 7 6 5 4 3 2 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details: _____					

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:		
		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- 0.010	.502	✓		Vernier	
2.790	+/- 0.010	2.795	✓		Vernier	
10.790	+/- 0.010	10.795	✓		Vernier	
14.790	+/- 0.010	14.795	✓		tape	
43.116	+/- 0.010	43.119	✓		tape	
44.866	+/- 0.010	44.870	✓		tape	
48.366	+/- 0.010	48.365	✓		tape	
60.366	+/- 0.010	60.365	✓		tape	
64.366	+/- 0.010	64.365	✓		tape	
74.366	+/- 0.010	74.370	✓		tape	
121.069	+/- 0.010	121.062	✓		tape	
123.324	+/- 0.010	123.325	✓		tape	
125.866	+/- 0.010	125.870	✓		tape	
127.616	+/- 0.010	127.625	✓		tape	
129.366	+/- 0.010	129.370	✓		tape	
131.116	+/- 0.010	131.120	✓		tape	
134.616	+/- 0.010	134.620	✓		tape	
136.366	+/- 0.010	136.370	✓		tape	
0.500	+/- 0.010	.500	✓		Vernier	
2.690	+/- 0.010	2.694	✓		Vernier	
4.690	+/- 0.010	4.698	✓		Vernier	
18.640	+/- 0.010	18.688	✓		tape	
15.24	+/- 0.030	15.25	✓		tape	
R1.0	+/- 0.100	R1.0	✓			
0.350	+0.000 - 0.020	.345	✓		pulper bars machine	
0.350	+0.000 - 0.020	.345	✓		pulper bars machine	
R1.0	+/- 0.100	R1.0	✓			
13.71	+/- 0.030	13.71	✓		tape	
0.150	+/- 0.015	.146	✓		pulper bars machine	
0.250	+/- 0.015	.240	✓		pulper bars machine	
9.35	+/- 0.030	9.35	✓		Vernier	
0.350	+0.000 - 0.020	.345	✓		pulper bars machine	

Measured by:	<i>mm</i>	Checked by:	<i>ank</i>	QC Inspector:	
Date:	2019/04/23	Date:	19/04/23	Date:	

Engineering Approval: (if necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

